DART AEROSPACE LTD	Work Order:	22128
Description: Bushing	Part Number:	D2617-5
Dwg: D2617 Rev. D1	Qty:	7425
		Page 1 of 1

Step	Location	Procedure	Ву	Date	Qty
1	DC	Issue Traveler	11	04.12-21	24
2	MC	Machine as per Folio FA438 and Dwg D2617 Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall (M6061T6T0.500W.058) Identify as D2617-5 Batch: [7] [57] 97	Ind		• > /-
3	QC2	Inspect parts as they come off the CNC machine	me	05/01/03	25
4	QC8	Second check	R	ostorloz	1
5	GA	Deburr break all unmarked sharp edges 0.005 to 0.010	BF	05-01-03	
6	FP	Acid Etch and Alodine as per QSI 005 4.1	0	05.01.03	
7	QC5	Inspect work to Step 6	61	05-01-03	
8	ST	Identify and Stock	M	05-01.03	
9	AC	Cost / part:		05.01.04	25
10	DC	Close W/O/, 0 8 Inspect Level 21	4	05.01.06	25

Rev	Date	Change	Revised By	Approved
D	98.04.16	Re-Format	КВ	1,5000
E	99.08.23	Re-format, added notes and inspection level	EC	
F	01.01.03	Re-format, made in-house	EC	1
G	01.01.08	Updated material NCR 467	EC	7
Н	04.07.14	Reformat; added step 5	KJ/JLM	Tull.

BELEASED

erospa	ce Ltd							
	· · · · · · · · · · · · · · · · · · ·	WC	ORK ORDER CHANGES	3				
STEP	PR	OCEDURE CHA	NGE `	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
	•				÷			
		WORK ORDI	ER NON-CONFORMAN	CE (NCR)			
	Description of NC	Corrective Action Section B			Verifica	ation	Approval	Approval
STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section	n C	Design Mgr	QC Inspector
							,	
• · · · · · · · · · · · · · · · ·		STEP PR	STEP PROCEDURE CHA	WORK ORDER CHANGES STEP PROCEDURE CHANGES WORK ORDER NON-CONFORMAN WORK ORDER NON-CONFORMAN STEP Description of NC Section A Initial Action Description	WORK ORDER CHANGES STEP PROCEDURE CHANGE By WORK ORDER NON-CONFORMANCE (NCR WORK ORDER NON-CONFORMANCE (NCR STEP Description of NC Section A Initial Action Description Sign &	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date WORK ORDER NON-CONFORMANCE (NCR) WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section A Section A Section A Section A Section B Section A Section B Section B Section A Section B Sectio	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty WORK ORDER NON-CONFORMANCE (NCR) WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Section C Section C	WORK ORDER CHANGES STEP PROCEDURE CHANGE By Date Qty Approval Mtg / Design Mgr WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Section C Section C Design Mgr

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	1/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	22128	
Description: Bushing	Part Number:	D2617-5	
Inspection Dwg: D2617 Rev: D1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.223	+0.000/-0.010	0.220			Ven	
0.500	+0.005/-0.000	0.500	/		Ven	
			,			
	\bar{q}					
	·					
					- 4	

Measured by:	The	Audited by:	R	Prototype Approval:	N/A
Date:	05/01/03	Date:	05/01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	,,,p,

RELEASED



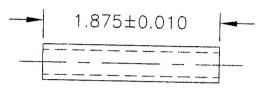


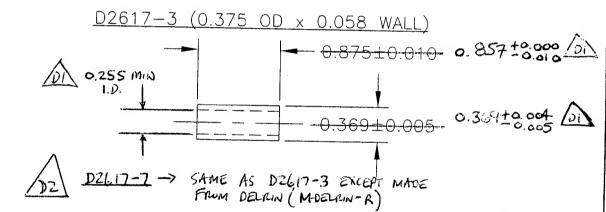
	DESIG	N	DRAWN BY	T	
1		BW	P	DART HAV	AEROSPACE LTD VKESBURY, ONTARIO, CANADA
,	CHEC	CED A	APPROVED	DRAWING NO.	REV. D
	DATE		<u>Al</u>	D2617	SHEET 1 OF 1
,				TITLE	SCALE
	01.0	7.04		BUSHING	1:1
	٨		00.00		

04.04.10#12 ADD 02617-7

NEW ISSUE 96.10.08 В 97.05.08 .875 WAS 1.125 C 97.06.04 0.369 DIA WAS 0.375 D ADD MAT'L SPEC AND TOL./DIM. NOTE 01.07.04 DI 04.07.12 CORRECT TOLERANCE (NCR 779)

D2617-1.058 WALL





0.223 + 9.000

D2617-5 (0.500 OD x 0.058 WALL)

SHOPLOP RET. ENG.XCE.XX

UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

1. . . 72128

NOTES:

MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)

OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)

BREAK ALL SHARP EDGES 0.005 TO 0.010

FINISH: ACID ETCH, ALODINE PER QSI 005 4.1

0.375 MIN

1.0.

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

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Market Televania () %			
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College And State State			
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Job Costing Report

Dart Aerospace Ltd. Hawkesbury

Dec 21, 2004 02:09 pm

Work Order No : 0022128 Project Name Project For : D2617-5

: WK502 Work Order Type : Main

Main WO Number House Part Number : D2617-5

Description : Spacer Manufactured : Yes

Amount Req'd: 24
Amount Done: 0

Amount Done : 0
Start Date : 12-21-04

Est Finish Date : 01-03-05 Act Finish Date :

Drawings Reqd : No Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000% Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
=======================================	======================================		=======	==========	===========
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		7
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00	Mr.	
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
		========	=======	¥.	
Burden	: 0.00	0.00	0.00		
	========	========	======		
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000	6.60		
Selling Cost	: 0.00	0.00			

Estimated Actual 0.00 0.00 Labour Hrs/Amount Done : 0.00 Profits/(Loss) 0.00